

Work Order ID 139132

November 18, 2015 9:32:49 AM

139132

Page 1

Item ID: D3212-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Interior Window For -015 & -025

Start Date: 11/13/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/16/2015 Req'd Qty: 1.00 *1*

Customer: CROGE01

Reference: RMA RA112106

Approvals: Process Plan: SH Date: 20151118

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3212

C

100

100

QC

Quality Control

Memo

0.00

INSPECT D3212-1 B113831 REV C ON RA112106

MAKE SURE THERE ARE NO SCRATCHES

REPACKAGE WINDOW AND STOCK WITH NEW BATCH NUMBER
139132

① 15-12-14 DAS
9
9-89

Scratch was found on
window.

110

Identify as per dwg & Stock Location: _____ 0.00

110

Packaging

Memo

0.00

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 139132

139132

Page 2

November 18, 2015 9:32:49 AM

Item ID: D3212-1 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Replacement Interior Window For -015 & -025
Start Date: 11/13/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 11/16/2015 Req'd Qty: 1.00 *1* Customer: CROGE01
Reference: RMA RA112106

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC21- Final Inspection - Work Order Release	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS DEC 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

*November 18, 2015 9:32:54 AM

Page 1

Work Order ID: 139132

139132

Parent Item: D3212-1

D3212-1

Parent Item Name: Replacement Interior Window For -015 & -025

Start Date: 11/13/2015

Required Date: 11/16/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A New Issue 05-11-09 JLM
 IPP Rev: B Water jet/ ecn798 06-05-08 EC
 IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3212-1		Manufactured	No				Each	9.0000		1			

D3212-1

Replacement Interior Window For -015 & -025

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST437	9	
113221	6	
113831	3	

D3212-1 x 1 B 113831 x 1 SH 20151118

RA112106

Received: November 9, 2015
Inspected: November 13, 2015

CUSTOMER: Rodgers Helicopters Inc.
CUSTOMER CONTACT: David Miranda
SHIPPED FROM: Fresno, California USA

Instructions for RA112106 D3212-1 B113831 Rev C

- Customer order parts by mistake
- Inspected window and make sure there's no scratch
- Repackage window and stock with new batch number

Instructions for RA112106 D2463-0450 B125469 Rev A

- Return in stock with original batch number

Time Estimate: 2 hours

Departments Required: Quality, small fab, stores

Pictures Attached: N/A

QTY INSPECTED: 1x D3212-1 B113831 Rev C

1x D2463-0450 B125469 Rev A

**THIS INSTRUCTION SHEET MUST BE
ATTACHED TO THE RESTOCKING
WORK ORDER AT ALL TIMES!!!!**